



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4091-1
Job Sheet 183439



Part No: D4091-1

Job Qty: 10 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D4091 Rev. A IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
100	Purchasing	10 pcs		10/5/18	0.00	0.00	Purchasing			SEP 20 2018
110	Packaging	10 pcs		10/5/18	0.00	0.00	Packaging2			SEP 20 2018
130	QC	10 pcs		10/5/18	0.00	0.00	QC6			38
160	QC	10 pcs		10/5/18	0.00	0.00	QC3			DAS-89
170	Packaging	10 pcs		10/5/18	0.00	0.00	Packaging3-2	57525		SEP 27 2018
180	QC21-SA	10 Ea		10/5/18	0.00	0.00	QC21			ML5 1809-24

Part Op
Descriptions: 100 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

10041060 SET 18. 2018 x10

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	1.2510 ft (.1251 ea)	100-Purchasing	5111815
D4091-1P	Lug	10 pcs (1 ea)	100-Purchasing	5111812

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2423	1	298	0
	D4091-1P	10	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	1.380Inches ± 0.030	1.410 1.350		
2	Mounting Lug	4.450Inches ± 0.030	4.480 4.420		
3	Mounting Lug	0.270Inches ± 0.030	0.300 0.240	Reference	
4	Mounting Lug	1.910Inches ± 0.030	1.940 1.880		
5	Mounting Lug	0.690Inches ± 0.030	0.720 0.660		
6	Mounting Lug	0.293Inches ± 0.010	0.303		



Container No: S111818



Part: D4091-1

Job No: 183439

Serial No/Batch: S111818

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/20/18

ER NON-CONFORMANCE / UPDATE

Work Order update only ☐



CTION

Rework ☐
Scrap ☐
Use-as-is ☐
Approved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐
Composite ☐

Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

QTY Effective :

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

Pressure/Forced ☐
Bending ☐
Centre Not Concentric ☐
Cracks ☐
Crimp/Kink/Ripple/Wave ☐
Cuffs ☐
Crushing ☐
Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

FAULT CATEGORY

Temperature/Cure ☐
Set-up ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Inspection Incomplete/Unqualified ☐
Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Positioned Wrong ☐
Outside Dimensions ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

OTHER :

			0.283	
7	Mounting Lug	0.735Inches $\pm$ 0.010	0.745 0.725	Reference
8	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
9	Mounting Lug	3.700Inches $\pm$ 0.010	3.710 3.690	
10	Mounting Lug	0.625Inches $\pm$ 0.010	0.635 0.615	
11	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Mounting Lug	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter
13	Mounting Lug	0.400Inches $\pm$ 0.030	0.430 0.370	Radius
14	Mounting Lug	2.310Inches $\pm$ 0.010	2.320 2.300	Reference

Plex 9/18/18 10:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

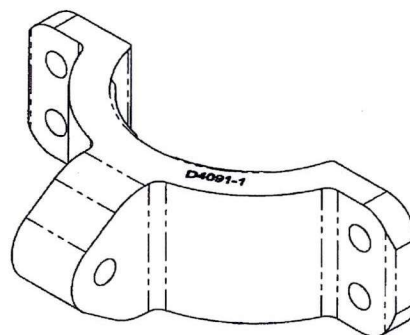


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



D4091-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183441 MWS
18-03-11

RELEASED
2010-04-28

NOTES:

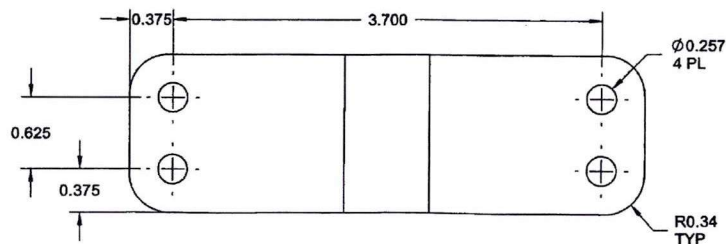
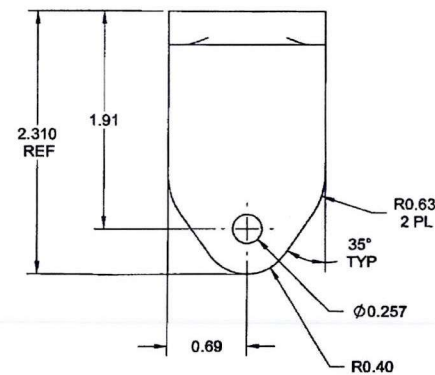
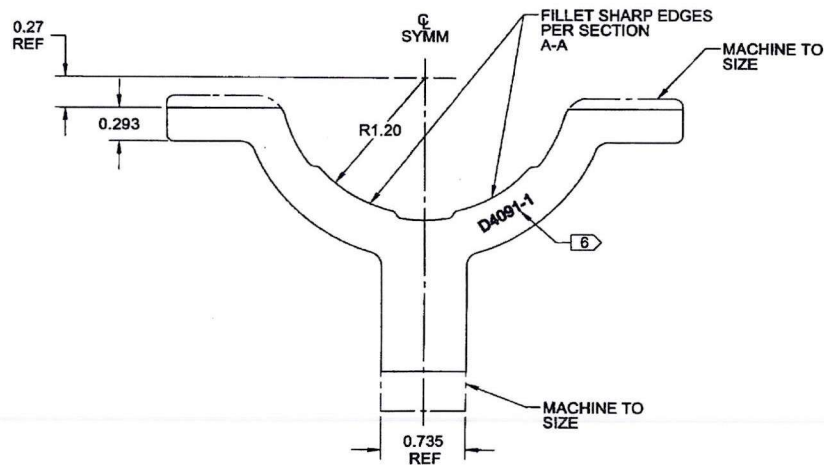
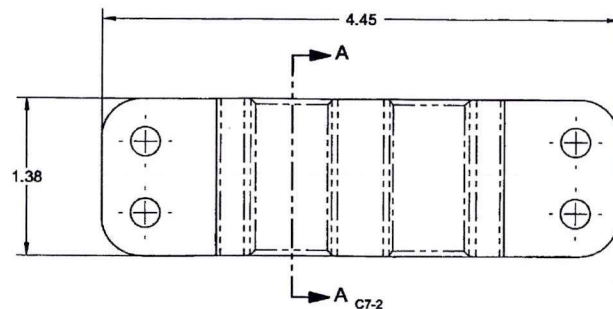
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4091	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		MOUNTING LUG	NTS		
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



R0.03-R0.07
TYP AROUND PAD

SECTION A-A
C5-2



D4091-1 MOUNTING LUG

RELEASED
2010-04-20

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4091	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041060

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041060

PO Date: 9/18/18

Due Date: 10/30/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183439	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	10/30/18	10 pcs	0 pcs	10 pcs	\$17.40/pcs	\$174.00

10 x SEP 20 2018

Line Item Note Alodine and Paint as per QSI 005

Grand Total: \$174.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 9/18/18 3:10 PM dart.Lussier.Patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24043
Shipment Date: 18-Sep-2018
Ship Via: YOUR TRUCK
Order Number: 3031
Order Date: 09/18/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041060 ✓
Terms: Net 30 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	10	10 ✓	0	0	EA	DART-D4091-1R ✓ Lug as per drawing D4091 Rev.A		3031-01

DAS
38
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
10 ✓	D4091-1 ✓	Mounting Lug	A	148835	21095	41060 ✓

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

DAS
38
9-89

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, September 19, 2018